

# ***Dow Corning***<sup>®</sup> EA-2626 Adhesive

## ***Dow Corning***<sup>®</sup> EA-2626 Base and ***Dow Corning***<sup>®</sup> Q3-3636 Catalyst

### **FEATURES & BENEFITS**

- 2-component adhesive/sealant
- Fast cure at room temperature
- Neutral alkoxy cure
- Non self-leveling, paste consistency
- Good, durable adhesion
- Excellent weathering, U.V. and heat resistance to 190°C
- Fast cure allows rapid handling of bonded components
- Fast cure in-depth, and not outside-inward cure like typical moisture cure adhesives

2-component, room-temperature curing, non self-leveling adhesive.

### **APPLICATIONS**

- *Dow Corning*<sup>®</sup> EA-2626 Adhesive has been developed to provide durable adhesive sealing for components which exhibit different thermal expansion rates, and /or where fast cure requirements make one part room temperature cure (RTV) adhesives inappropriate.
- A typical example in automotive manufacturing is the bonding of polycarbonate or glass lenses to the reflector housing of headlamps and fog lamps.
- *Dow Corning* EA-2626 Adhesive is also a perfect solution in appliances manufacturing, especially for oven and ceramic hob assembly, for bonding glass to metal, glass to painted metal or glass to plastic.

### **TYPICAL PROPERTIES**

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

Test*	Property	Unit	Result	
<b><i>Dow Corning</i></b> <sup>®</sup> EA-2626 Base				
	Appearance		White paste	
D 1084	Viscosity	mPa.s	205000	
D 1475	Specific gravity		1.36	
<b><i>Dow Corning</i></b> <sup>®</sup> Q3-3636 Catalyst				
			<b>Grey</b>	<b>Special Black</b>
D 1084	Viscosity	mPa.s	18000–48000	350000** (ca.)
D 1475	Specific gravity		1.00	1.04
<b><i>Dow Corning</i></b> EA-2626 Base with <b><i>Dow Corning</i></b> Q3-3636 Catalyst (100 pts base:13 pts catalyst)				
	Working time, snap	minutes	6–9	6–9
	Tack free time	minutes	11–18	11–18
D 1475	Flow	mm	<2	<2
	Specific gravity		1.32	1.33
	Color - RAL code		7000	7021

\*Materials were tested according to Dow Corning Corporate Test Methods (CTM), which in most cases are similar to the ASTM (American Society for Testing and Materials) standards listed above.

\*\*A penetration test is used to measure consistency of Catalyst Special Black. Value 180–460 mm/10.

## TYPICAL PROPERTIES (Continued)

Test*	Property	Unit	Result	
			Grey	Special Black
<b>Properties after full cure – 7 days at 23°C – measured on 2 mm sheets</b>				
D 2240	Durometer	Shore A	43	45
D 412	Tensile strength	MPa	>1.9	>1.9
D 412	Elongation at break	%	>200	>200
<b>Adhesion via Peel Test – 24 hours cure at 23°C on clear polycarbonate</b>				
	Cohesive failure	%	100	100
<b>Adhesion via Lap Shear – 24 hours at 23°C on PC/glass and PBT-ASA blend/glass</b>				
Lap shear strength				
	PC / PP***	MPa	>1.0	>1.0
	PC / glass	MPa	>1.0	>1.0
	PBT-ASA / glass	MPa	>1.0	>1.0
Cohesive failure				
	PC / PP***	%	100/100	100/100
	PC / glass	%	100/100	100/100
	PBT-ASA / glass	%	100/100	100/100

\*\*\*PP treated with plasma

### DESCRIPTION

*Dow Corning* EA-2626 Adhesive is a 2-component, non self-leveling adhesive with fast cure at room temperature.

The product has been developed to show good, durable adhesion to a range of substrates including plastics, metals and glass.

### HOW TO USE

#### Mixing

The adhesive is designed to be used with *Dow Corning*® Q3-3636 Grey and Special Black Catalysts in a mix ratio of 100 parts Base: 13 parts Catalyst by weight, (or 5.7–5.9 parts Base: 1 part Catalyst by volume of *Dow Corning* Catalyst Grey and Special Black respectively). Other mixing ratios can be used but *Dow Corning* should be consulted prior to use. Suitable meter/mix equipment should be equipped with gear or piston metering pumps for base and catalyst, and a suitable static or a dynamic mixer.

### Curing Conditions

The adhesive cures at room temperature and develops adhesion rapidly to glass, plastic and metal substrates.

The surfaces to be bonded should be clean, and free of any extraneous matter, dust or dirt.

Adhesion is normally good to most substrates (see Note) without the use of a primer, or of surface activation methods. If desired, adhesion may be enhanced via use of flame or plasma treatment of the surfaces to be bonded. The cure and adhesion strength can also be accelerated by the application of moderate heat, for example 10 minutes at 60–70°C.

#### Note

Adhesion to low energy surfaces like polypropylene can be achieved via use of plasma or flame treatment.

### Hot and Humid Resistance

*Dow Corning* EA-2626 Adhesive shows good adhesive resistance to hot

and humid conditions, for example 7 days in water at 70°C.

### HANDLING

#### PRECAUTIONS

**PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND MATERIAL SAFETY DATA SHEETS AND CONTAINER LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE MATERIAL SAFETY DATA SHEET IS AVAILABLE ON THE DOW CORNING WEBSITE AT DOWCORNING.COM, OR FROM YOUR DOW CORNING SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CORNING CUSTOMER SERVICE.**

### USABLE LIFE AND STORAGE

When stored at or below 32°C in the original unopened containers

Dow Corning EA 2626 Base has a usable life of 12 months from date of production.

When stored at or below 25°C in the original unopened containers Dow Corning Q3-3636 Catalysts Grey and Special Black have a usable life of 5 months from date of production.

## **PACKAGING INFORMATION**

This product is available in different standard container sizes. Detailed container size information should be obtained from your nearest Dow Corning Sales Office or Dow Corning Distributor.

## **LIMITATIONS**

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

## **HEALTH AND ENVIRONMENTAL INFORMATION**

To support customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our website, [dowcorning.com](http://dowcorning.com) or consult your local Dow Corning representative.

## **LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY**

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

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